

27

DART AEROSPACE LTD.	Work Order:	20965
Description: Saddle Fitting, Fwd (Outboard/Inboard)	Part Number:	D2571/D2572
Drawing: D2571 Rev. D/D2572 Rev. D	Qty:	8
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller Dwg not required	KJ	04.06.01	8
2	MV	Make from D6101-007 billet for D2571 Ensure that grain is along 7.75" length Batch No: B20724	EN	04/06/28	8
3	MV	Make from D6101-005 billet for D2572 Ensure that grain is along 5.00" length Batch No: B20723	EP	04/06/28	8
4	MV	Fixturing W/O No. N/A Fixturing Inspection last completed 04/06/28 by EN	ED	04/06/28	8
5	MV	Program Batch No. B20965 Double check by: GJ	EN	04/06/28	8
6	MV	Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets	EN	04/06/30	8
7	MV	Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets	EN	04/06/30	8
8	MV	Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets	EN	04/07/01	8
9	MV	Machine keyway as per dwg D2571 & D2572	EN	04/07/01	8
10	MV	Deburr and remove all machining marks	EN	04/07/01	8
11	MV	Tumble for 20 minutes	EN	04/07/01	8
12	QC1	Inspect all dimensions to dimension sheets	EP	04/07/01	8
13	QC7	Second inspection	EP	04.07.05	8
14	FP	Acid etch and alodine as per QSI 005 4.1	ML	04.07.05	8
15	FP	Powder Coat High Gloss White (4.3.5.1) per QSI 005 4.3	ML	04.07.05	8
16	QC3	Inspect Powder Coat	Z	04.07.06	8
17	ST	Identify and Stock.	CL	04/07/06	8
18	AC	Cost / Part 107.01 84.61	SAC	04.07.07	8
19	DC	Close W/O 104.90 83.02 Inspection Level 21	KJ	04.07.09	8

Rev	Date	Change	Revised By	Approved
G	01.04.27	Added D6101-007 & step 8	EC	
H	02.02.01	Added Inspection level 5 and Inspection Level 21	SM	
I	02.10.02	Re-format; Change to Dwg Rev. D & incorporated D2572	KJ RF	

RELEASED
02/10/15 RF